

Date: Wednesday, 22/10/2008 4:43:47 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212 X-TUBE ,LOW STANDARD AFT
Job Number	: 42878		
Estimate Number	: 13019		
P.O. Number	:	Part Number	: D212664207
This Issue	: 22/10/2008 S.O. No. :	Drawing Number	: D212-664-247 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A
Previous Run	: 42877	Material	:
Written By	:	Due Date	: 07/11/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JUD 08.10.22</u>		
Comment	: Est Rev:A New Issue 07:09:12 EC verified by: JLM Est Rev:B ECN 1100p 08-01-11 DD verified by: EC Est Rev:C ECN 1121 08-02-25 DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JUD 08.11.10



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-207 CHG001

5 08/12/08

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

3.0	D212664207TRN	Crosstube Turning Detail
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *B43050*

MB / DP 8-11-12

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-247 using CNC bender program and Folio FT

MB / DP 8-11-13

5.0	QC6 QC15	DIMENSIONAL CHECK
-----	------------------------	-------------------



Comment: DIMENSIONAL CHECK

08.11.13

P10

W/O		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-11-13	5.0	QC-15 required. Perm. Change.	HJ	08.12.09		08-11-13	08-11-13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 212 X-TUBE LOW STANDARD AFT

Job Number: 42878

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D36601

CUFF



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
CUFF

Batch:

B36835

DP

8-11-13

7.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Rivet holes as per Dwg D212-664-247 using DT8972.

2-Drill pilot holes in tube as per Dwg D212-664-247

3-Ream hole to finish size in tube as per Dwg D212-664-247

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-247

4-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-247

ET 08-11-18

AWM 8-11-18

ET 08-11-18

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1

AWM 8-11-15

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/11/19 (X)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/19 (X)

11.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: *7621* LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C208/11/19 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 4:43:47 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW STANDARD AFT

Job Number: 42878

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

Piggy 179 *U*

13.0

QC5

INSPECT WORK TO CURRENT STEP



ml 08 11 20



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

14.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet Cuffs as per Dwg D212-664-247. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291 BATCH: 109449

ET 08-11-20

15.0

CR3212406

CHERRY RIVET



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

CHERRY RIVET

Batch: 104093

ET 08-11-20

16.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 08 12 03 *(U)*

17.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

S 08/12/05 *(U)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW STANDARD AFT

Job Number: 42878

Part Number: D212664207

Job Number:



Seq. #:	Machine Or Operation:	Description :
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24.0	AN641A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt
batch M107013

SS 08/12/08 (X)

25.0	MS21042L6	Nut
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)
Nut
batch M108183

SS 08/12/08 (X)

26.0	AN960JD616	Washer
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Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)
Washer
batch M109371

SS 08/12/08 (X)

27.0	D34281	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Placard
batch 42448

SS 08/12/08 (X)

28.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/12/08 (X)

29.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Identify and pack for shipping as per PPP D212-664-207

Per draft

8/12/08

(X)
SP

30.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/12/09 J

Job Completion



MF 08-12-08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 4:43:47 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 42878

Part Number: D212664207

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	D29401	Support
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Support
batch: 40753

ml 08 12 04

19.0	D3595063530	RUBBER CUSHION
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Rubber Cushion
Batch: 39255

ml 08 12 04

20.0	MS2192028	Clamp(per MIL-DTL-8783C)
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Clamp
Batch: 109181

ml 08 12 04

21.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Assemble as per Dwg D212-664-247

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3- Instal support with magnobond 6398 per dwg D212-664-247,
cure for 12hrs before packaging.

Time & date of application: 08 12 04 / 10:15 AM
Batch: ~~109900~~ 109900
EXP. DATE 02/2010

Torque: ml 08 12 05 ①

ml 08 12 04 ①

22.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5 08/12/05 (X)

23.0	AN640A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Bolt
batch 108940

88 08/12/08 (X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

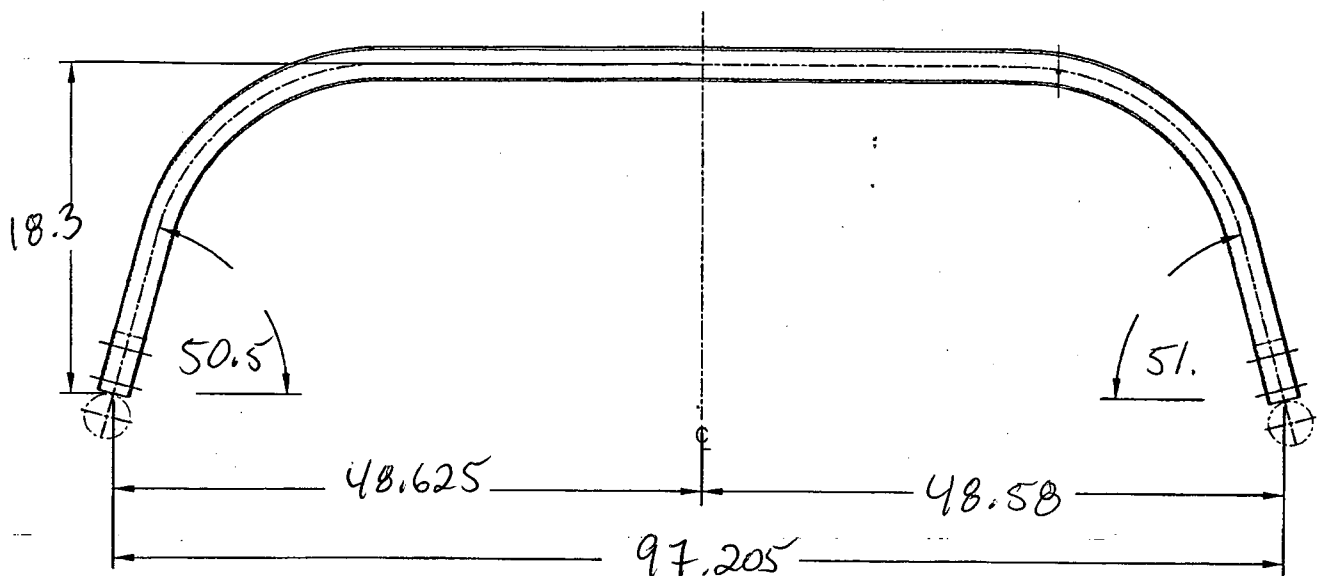
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	42878
Description: Crosstube Low Aft (205/212)		Part Number:	D212-664-207
Inspection Dwg: D212-664-247 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	18.16	18.42
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62



Comments

QC15 Inspection	<i>[Signature]</i> 2084.13
Date	

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST:

Qty	Part Number	Description
X	D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
1	D6008-132	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
2	D3660-1	CUFF
4	MS21920-28	CLAMP (OR MS21920-30)
44	CR3212-4-06	RIVET (OR M7885/3-4-06)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6008-132
FINISHED LENGTH = 128.27±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE.
- 6) WHEN MACHINING TAPER, RUN-OFF PART AT STOCK. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 7) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 8) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 9) SCRIBE DART PART NUMBER AND BATCH NUMBER ON INNER SURFACE OF TUBE WITH A
VIBRATING STYLUS.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1
THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE
D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE
CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY
AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A
LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN
CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

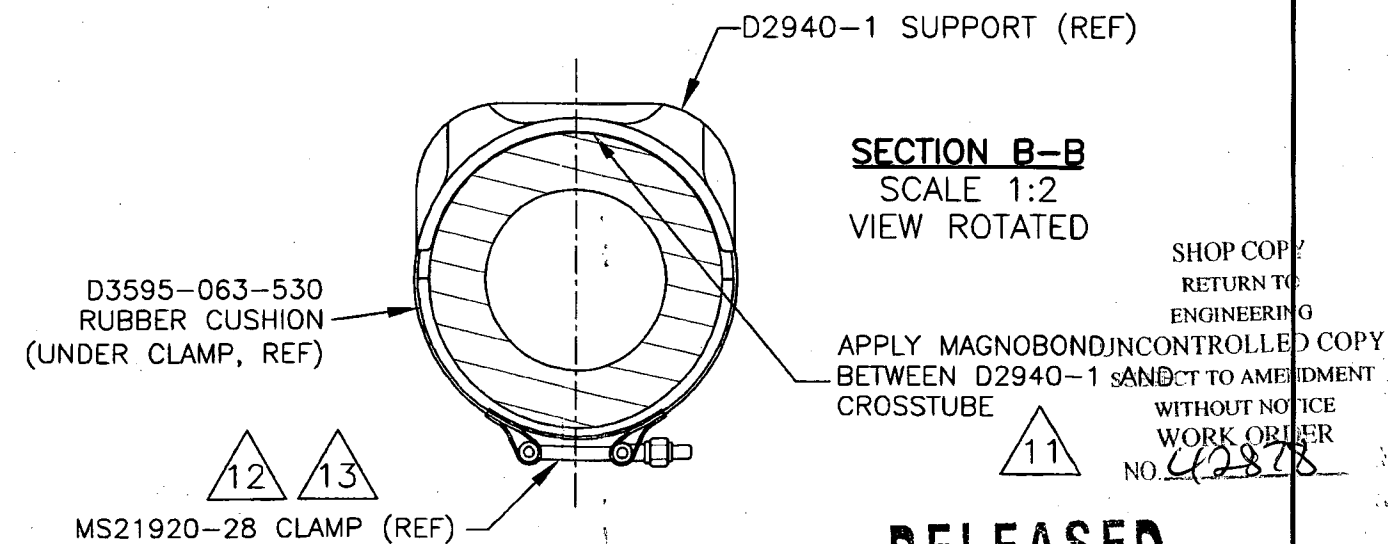
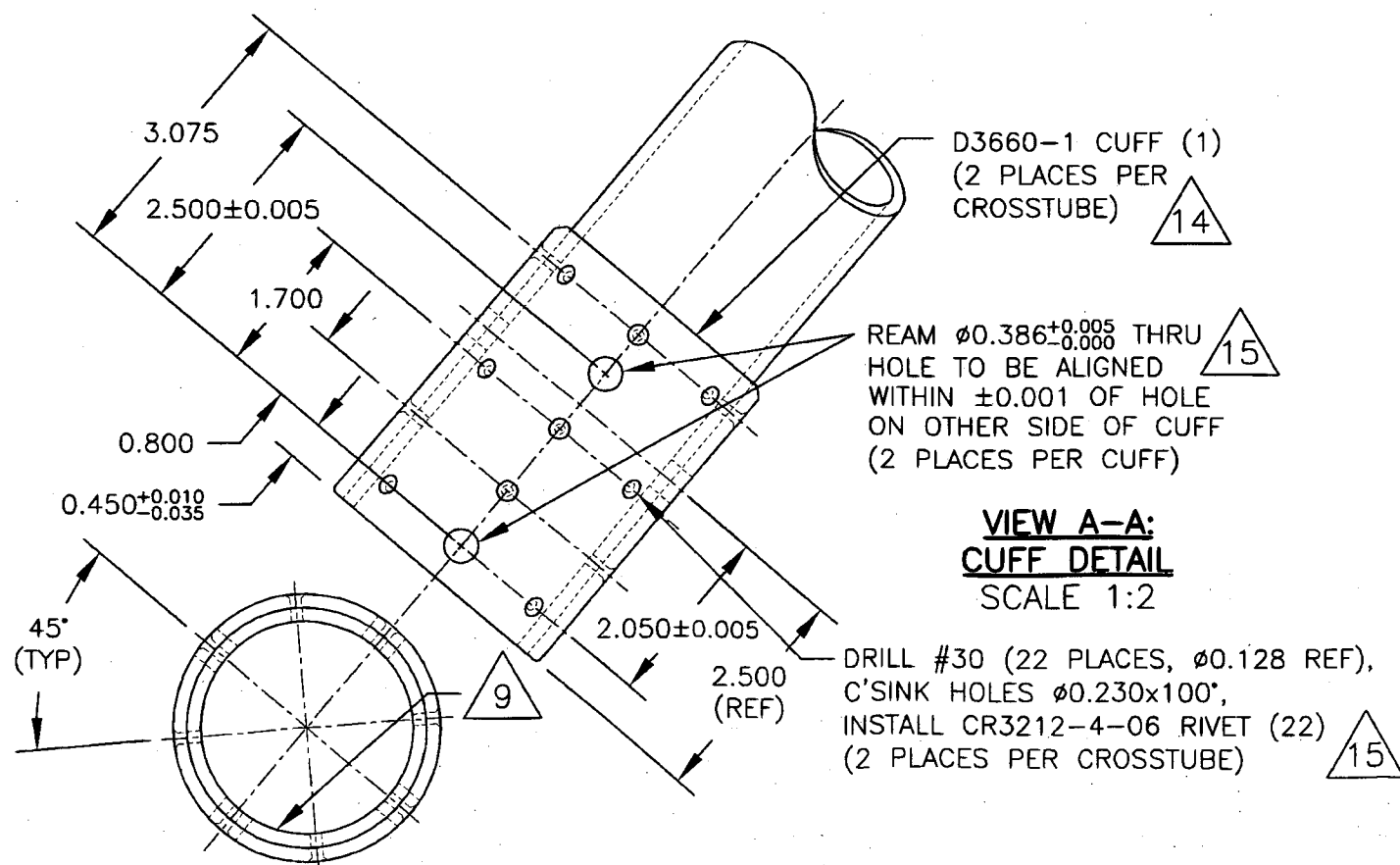
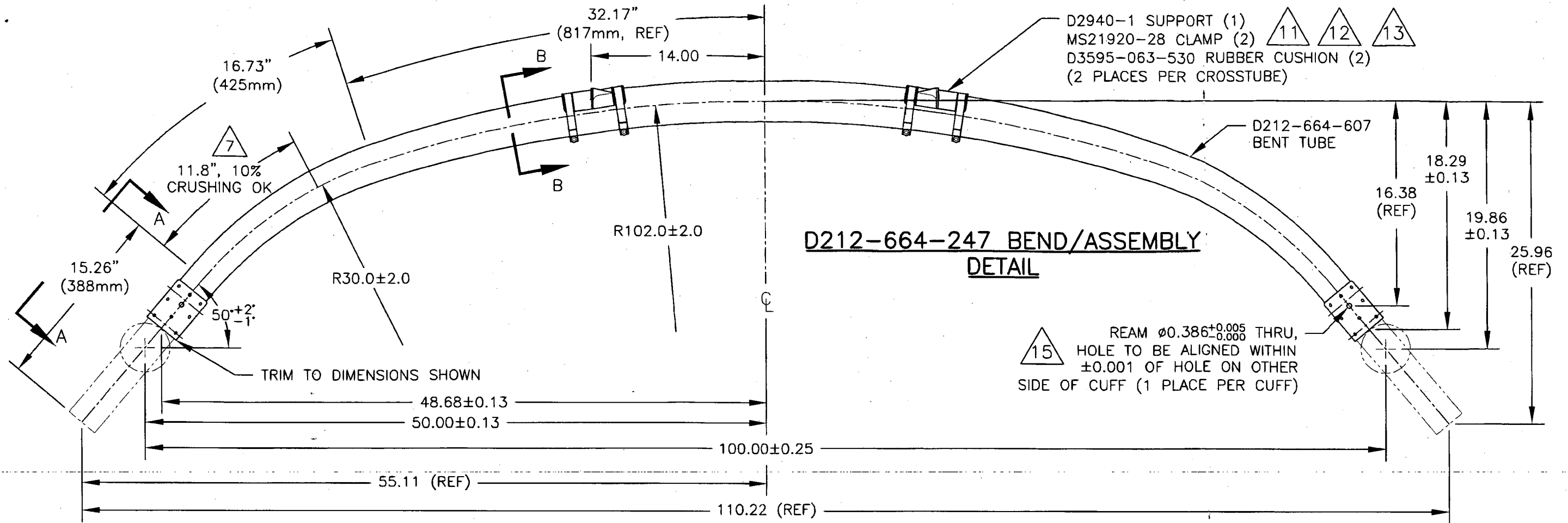
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WORK ORDER
NO. 42878

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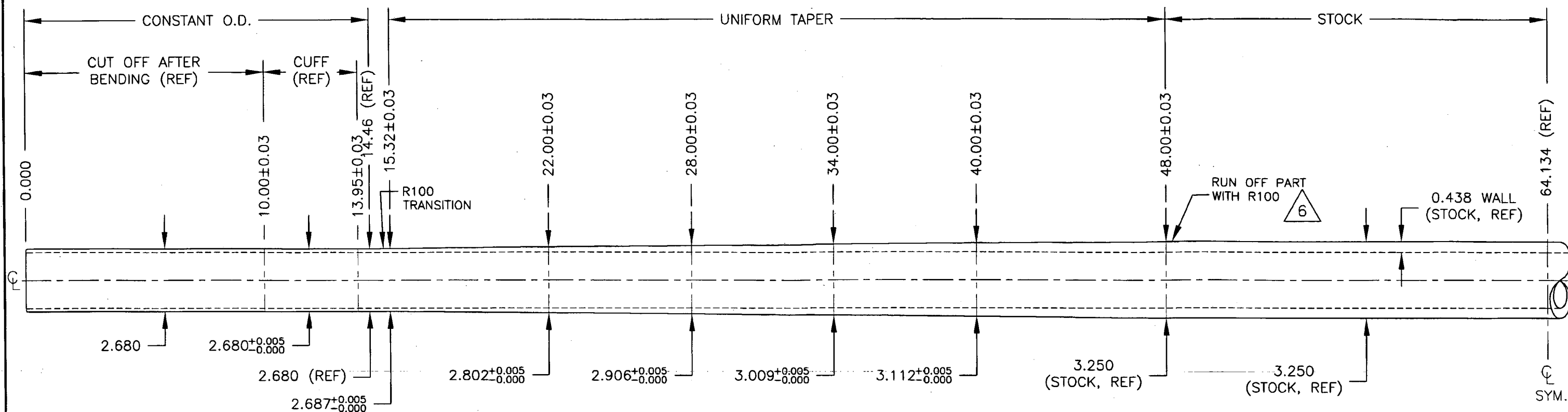
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A	07.07.07	NEW ISSUE
DESIGN QP	DRAWN BY QP	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED H	DRAWING NO. D212-664-247
DATE 07.07.07	TITLE CROSSTUBE (205/212 LOW AFT)	REV. A SHEET 1 OF 3 SCALE NTS



RELEASED
07.09.24

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		DATE	07.07.07			D212-664-247	SHEET 2 OF 3
						TITLE	SCALE
						CROSSTUBE (205/212 LOW AFT)	1:8



D212-664-247 MACHINING DETAIL

RELEASED
07.09.24

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NO. 42828

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DATE		07.07.07		DRAWING NO.	REV. A
				D212-664-247	SHEET 3 OF 3
				TITLE	SCALE
				CROSSTUBE (205/212 LOW AFT)	1:4



LIQUID PENETRANT TEST REPORT

P-08827

CLIENT DAOT Aerospace DATE Nov. 19-2008 PAGE 1 OF 1
 ATTENTION Linda Lacelle ACUREN JOB NO. 188-09-1121 TIME AM ☒ PM ☐
 ADDRESS 1270 ABERDEEN ROOM NO. 7627
Hawkesbury, ON WORK LOCATION SAME ADDRESS, SHOP
 PROJECT N/A ACCEPTANCE STD. QST-038 REV/DATE 2005
 ITEM(S) EXAMINED 407 HIGH AFT X-TUBE ASSEMBLY, 407 FWD X TUBE
212 X-TUBE ROW STANDARD AFT

JOB DESCRIPTION PROCEDURE NO. LT-X001 REV/DATE 16 NOV 07 TECHNIQUE NO. LT-X002XX REV/DATE NOV. 07 08
 PART NO. D212-664-247/D407667265/D407667105 MATERIAL ALODINED ALUM. THICKNESS
 SCOPE 100% EXTENDED WET FLOURESCENT INSPECTION
ON UNITS

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
 FAMILY BRAND 2607 MINIMUM DWELL TIME 10 MIN. BLACK LIGHT S/N 8171 ☒ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
 PENETRANT H2O MINIMUM DRY TIME >10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
 DEVELOPER SK052 MINIMUM DWELL TIME 10 MIN. OTHER CAL FEB 12-08
 DEVELOPER TYPE ☐ NON-AQUEOUS ☐ AQUEOUS ☐ DRY LIGHT METER S/N CAL DUE DATE

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☐ CLEAN BARE METAL
 SURFACE TEMPERATURE ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- ☐ METRIC ☐ IMPERIAL

ITEM	COMMENTS	ACCEPT	REJECT
SB	units		
#	41042	/	
	42878	/	
	43340	/	
	41043	/	
No INDICATIONS			
WELLS FOUND ON THESE			
PARTS THAT WERE			
EXAMINED			

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the Standard of Care.

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Jason Kuvshinov DTR # E-20057
 TECHNICIAN (SIGNATURE) [Signature] SIGNATURE
 NAME (PRINT): Nike Johnson REPORT REVIEWED BY:
 CGSB LEVEL II SNT LEVEL CGSB LEVEL SNT LEVEL
 CGSB REG. NO. 0666 CGSB REG. NO.

